

Date: Tuesday, 16/09/2008 3:28:21 PM
User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	TUNNEL BOTTOM PANEL		
Job Number	42038			Part Number	D3649041		
Estimate Number	13026			Drawing Number	D3649 REV.B		
P.O. Number				Project Number	N/A		
This Issue	16/09/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	30/09/2008		
Previous Run	42022			Qty:	5	Um:	Each
Written By							
Checked & Approved By	<u>JUL 08.9.16</u>						
Comment	Est Rev:A New Issue 07-09-26 EC verified by: DD Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C Ecn1162 08-04-02 DD verified by:EC						

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :	Comments:	Barcode	Barcode	Barcode	Barcode
1.0	M304S26GA	304/316 0.018 SHEET	Comment: Qty.: 6.3725 sf(s)/Unit Total : 31.8623 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>100115</u> HB 8-9- 18 26	<i>MAT NOT pulled</i> cut out	POSITIVE RECALL	EFFECTIVE <u>08.9.16</u> AUTH <u>U</u>	RELEASED <u>U</u> DATE <u>08.9.16</u>
2.0	WATER JET <u>109 348</u>	FLOW WATER JET	Comment: FLOW WATER JET 1-Cut as per Dwg D3649 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>	HB 8-9- 18 26	(4)		
			2-Deburr if necessary	HB 8-9- 18 26			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	HB 8-9- 18 26			
4.0	QC8	SECOND CHECK	Comment: SECOND CHECK	HB 8-9- 18 26	26	S 08.09.16 (26)	
5.0	BRAKE NC	NC BRAKE	Comment: NC BRAKE Form as per Dwg D3649	HB 8-9- 18 26	26	SB 08/09/29	(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:21 PM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/09/29 QC

Comment: INSPECT WORK TO CURRENT STEP

7.0 MS210603K

Nut Plate



Comment: Qty.: 22.0000 Each(s)/Unit Total: 110.0000 Each(s)

Nut Plate

MW 9371

152

8.0 MS210623K

Nut Plate



Comment: Qty.: 22.0000 Each(s)/Unit Total: 110.0000 Each(s)

Nut Plate

M108669 38X

109438

132

9.0 MS20427M33

Rivet



M109371

PC 8/10/01

Comment: Qty.: 88.0000 Each(s)/Unit Total: 440.0000 Each(s)

Rivet

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Form dimple for MS20427M3 rivet per dwg D3649

*****ensure dimples are on the proper side*****

2-Assemble nutplates as per dwg D3649

11.0 QC5

INSPECT WORK TO CURRENT STEP



EP 08/10/02 6

S 08/10/02 6

Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

S 08/10/02 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:21 PM
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Drawing Name: TUNNEL BOTTOM PANEL

Job Number: 42038

Part Number: D3649041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/03 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



✓ 08.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42038
Description: Tunnel Bottom Panel	Part Number: D3649-1
Inspection Dwg: D3649 Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.00.098	+0.004/-0.001	.102	X			
.00.196	+0.005/-0.001	.200	X			
.00.250	+0.005/-0.001	.254	X			
.400	+/-0.010	.403	X			
.385	+/-0.010	.387	X			
.250	+/-0.010	.252	X			
44.57	+/-0.030	44.57	X			
11.70	+/-0.030	11.70	X			
3.370	+/-0.030	3.370	X			
13.76	+/-0.030	13.76	X			
4.300	+/-0.010	4.300	X			
10.11	+/-0.030	10.11	X			
12.90	+/-0.030	12.90	X			
16.61	+/-0.030	16.61	X			
15.80	+/-0.030	15.80	X			
3.950	+/-0.010	3.950	X			
.42	+/-0.030	.421	X			
.41	+/-0.030	.408	X			
.85	+/-0.030	.858	X			
19.64	+/-0.030	19.40	X			
.54	+/-0.030	.54	X			
1.400	+/-0.010	1.395	X			
2.63	+/-0.030	2.626	X			
2.93	+/-0.030	2.921	X			
1.49	+/-0.030	1.447	X			
5.98	+/-0.030	5.977	X			
.54	+/-0.030	.54	X			
2.20	+/-0.030	2.196	X			
2.75	+/-0.030	2.74	X			
2.48	+/-0.030	2.470	X			

DART AEROSPACE LTD	Work Order:	42038
Description: Tunnel Bottom Panel	Part Number:	D3649-1
Inspection Dwg: D3649 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

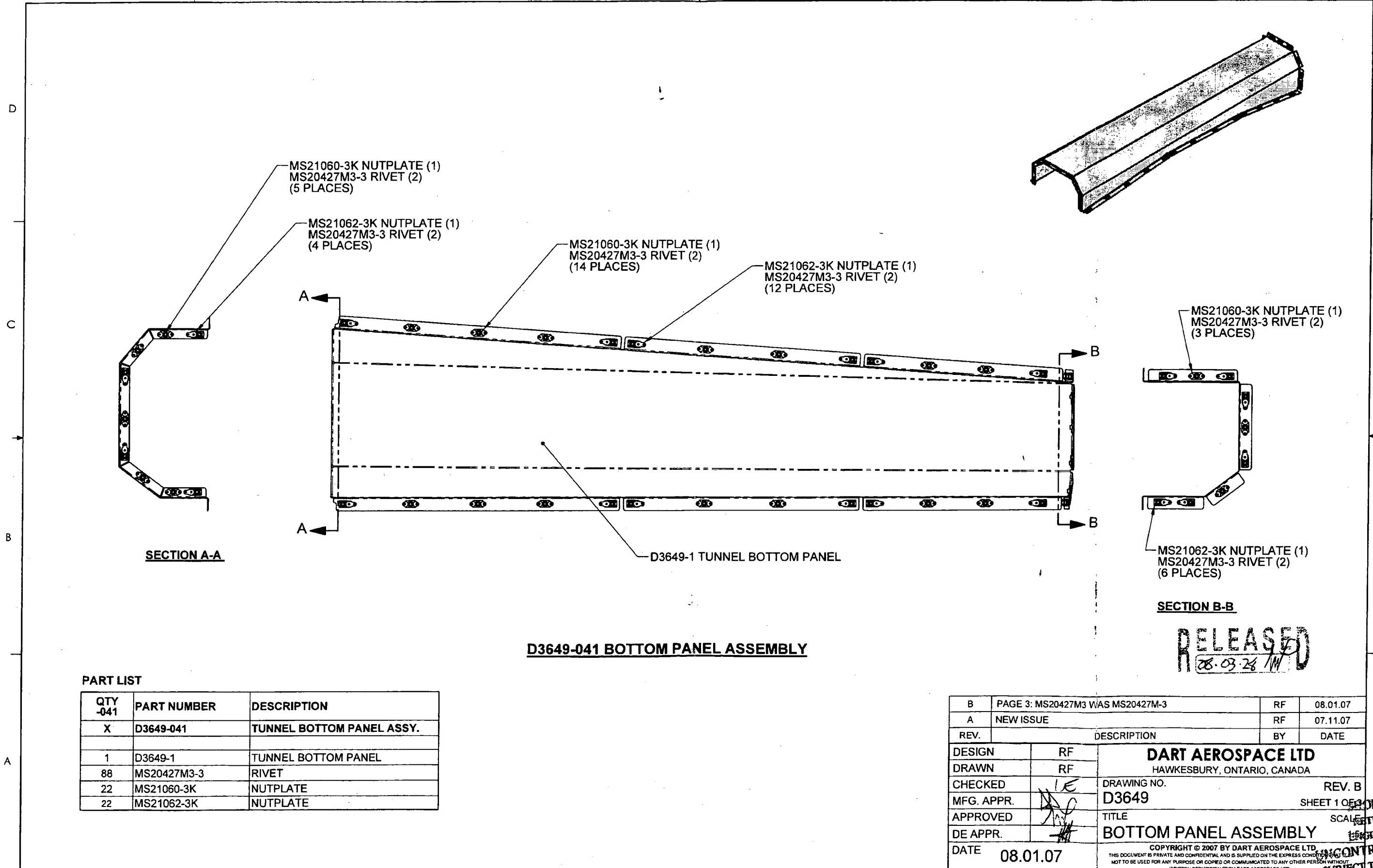
First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.164	X			
3.38	+/-0.030	3.373	X			
2.00	+/-0.030	1.997	X			
0.90	+/-0.030	.894	X			
16.64	+/-0.030	16.60	X			
0.48	+/-0.030	.499	X			
13.80	+/-0.030	13.80	X			
0.46	+/-0.030	.479	X			
11.76	+/-0.030	11.75	X			
1.23	+/-0.030	1.226	X			
0.88	+/-0.030	.901	X			
18.46	+/-0.030	18.46	S			
5.23	+/-0.030	5.233	X			
1.932	+/-0.010	1.940	X			
1.943	+/-0.010	1.940	X			
5.02	+/-0.030	5.018	X			
1.820	+/-0.010	1.818	X			
0.70	+/-0.030	.709	X			
2.100	+/-0.010	2.101	X			
2.33	+/-0.030	2.332	X			
0.94	+/-0.030	.938	X			
3.30	+/-0.030	3.293	X			
1.900	+/-0.010	1.894	X			
0.61	+/-0.030	.607	X			

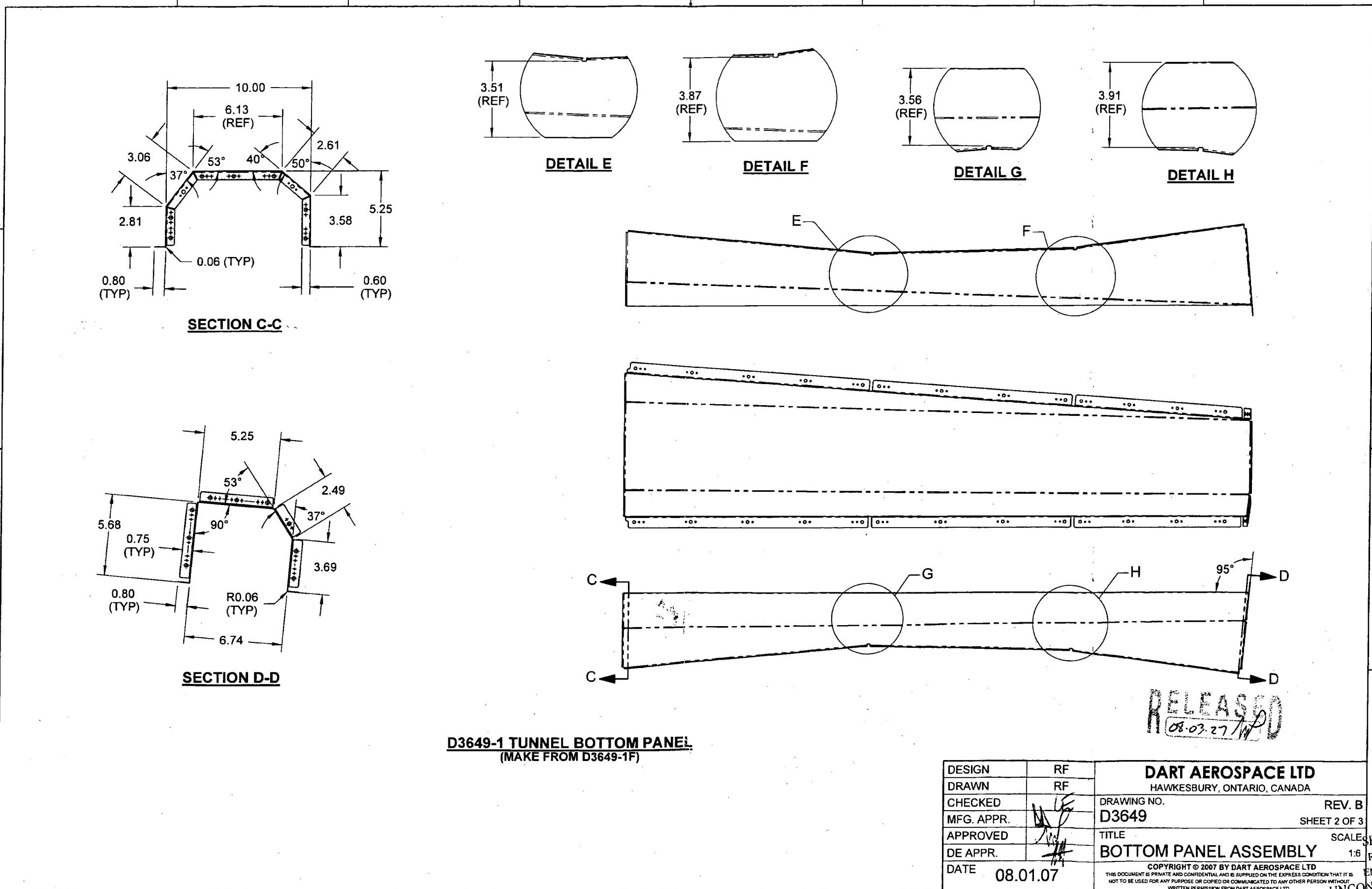
Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	8-9-17	Date:	08/09/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	DA

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



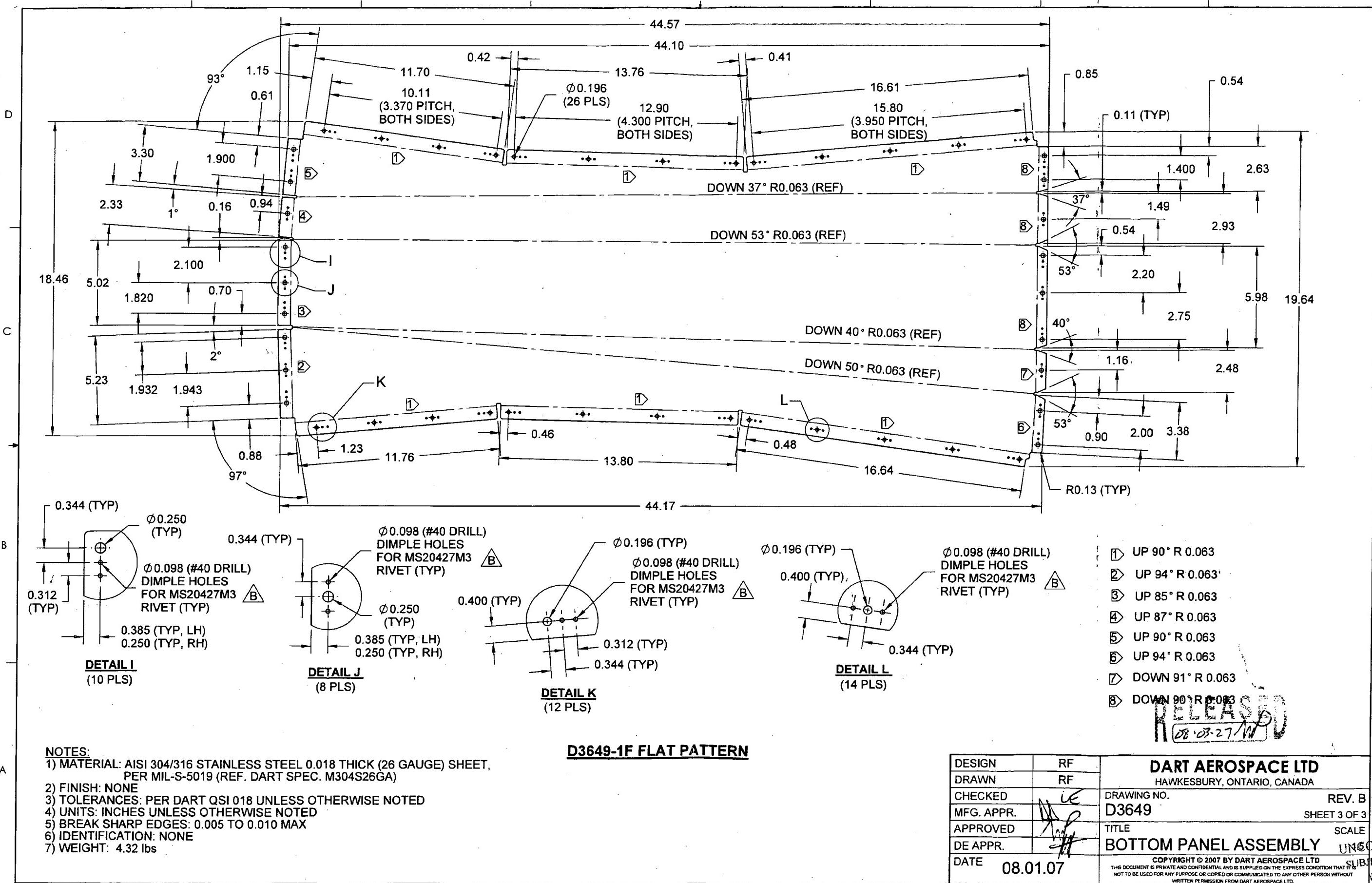
D3649-1 TUNNEL BOTTOM PANEL
(MAKE FROM D3649-1F)

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3649
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 2 OF 3
DATE	08.01.07	TITLE
		BOTTOM PANEL ASSEMBLY

RELEASED
08-03-27

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NO. 12038



DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.	AP	D3649
APPROVED	AP	REV. B
DE APPR.	AP	SHEET 3 OF 3
DATE	08.01.07	SCALE
		TITLE
		BOTTOM PANEL ASSEMBLY
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